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[TXD 8: Handloom and Khadi]

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SPECIFICATION FOR HANDLOOM COTTON CALICO, BLEACHED OR DYED

(First Revision)

UDC 677·21·074·162·3

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BUREAU OF INDIAN STANDARDS
MANAK BHAVAN, 9 BAHADUR SHAH ZAFAR MARG
NEW DELHI 110002

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June 1988

Indian Standard

SPECIFICATION FOR HANDLOOM COTTON CALICO, BLEACHED OR DYED

(First Revision)

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Indian Standard

SPECIFICATION FOR HANDLOOM COTTON CALICO, BLEACHED OR DYED

(First Revision)

0. FOREWORD

0.1 This Indian Standard (First Revision) was adopted by the Bureau of Indian Standards on 28 August 1987, after the draft finalized by the Handloom and Khadi Sectional Committee had been approved by the Textile Division Council.

0.2 This Indian Standard which was published in 1958 has been taken up for revision in order to make it up-to-date. The major changes carried out in the present version are :

a) Deletion of breaking load requirement since yarn conforming to IS : 171-1985* has been specified;

b) Count of yarn has been specified 'for guidance only',

c) Latest version of Indian Standards on test methods have been referred, and

d) Clause on 'Inspection' has been included.

0.3 For the purpose of deciding whether a particular requirement of this standard is complied with, the final value, observed or calculated, expressing the result of a test or analysis, shall be rounded off in accordance with IS : 2-1960†. The number of significant places retained in the rounded off value should be the same as that of the specified value in this standard.

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1. SCOPE

1.1 This standard prescribes constructional particulars and other requirements of handloom cotton calico, bleached or dyed.

*Specification for cotton and cotton regenerated cellulosic fibre blended grey yarn (*third revision*).

†Rules for rounding off numerical values (*revised*).

1.2 This standard does not specify the type of finish, general appearance, lustre and feel of cloth nor does it specify the degree of whiteness of bleached cloth or the colour of dyed cloth.

2. MANUFACTURE

2.1 Yarn — The cotton yarn used in the manufacture of calico cloth shall conform to Grade HL of IS : 171-1985*.

2.2 Cloth — The cloth shall be free from substances liable to cause subsequent tendering.

3. REQUIREMENTS

3.1 The constructional particulars of calico cloth shall conform to those given in Table 1.

3.2 The calico cloth shall also conform to the requirements given in Table 2.

3.3 If in order to illustrate or specify the indeterminable characteristics such as general appearance, lustre, feel, and shade of the cloth, a sample has been agreed upon and sealed, the supply shall be in conformity with the sample in such respects.

3.3.1 The custody of the sealed sample shall be a matter of prior agreement between the buyer and the seller.

4. INSPECTION

4.1 The cloth when visually inspected, should be reasonably free from the following defects :

a) Weft crack or more than two missing picks across the width;

b) Prominently noticeable weft bar due to the difference in raw material, count, twist, lustre, colour, shade, etc;

c) More than two adjacent ends running parallel, broken or missing and extending beyond 15 cm;

d) Prominent selvedge defects;

e) Noticeable warp or weft float;

f) Noticeable oil or other stains;

g) Noticeable hole, cut or tear up to 3 mm in size;

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*Specification for cotton and cotton regenerated cellulosic fibre blended grey yarn (*third revision*).

h) Smash rupturing the texture of the fabric; and

j) Prominently noticeable dyeing defects (bars, streaks and patches, etc).

4.1.1 A reference may be made to IS : 4125-1967* for details of these defects.

5. MARKING

5.1 The cloth shall be suitably marked or labelled with the following information :

a) Name of the material;

b) Manufacturer's name, initals or trade-mark;

c) Month and year of manufacture; and

d) Length and width of piece.

5.1.1 The cloth may also be marked with the Standard Mark.

NOTE — The use of the Standard Mark is governed by the provisions of the Bureau of Indian Standards Act, 1986 and the Rules and Regulations made thereunder. The Standard Mark on products covered by an Indian Standard conveys the assurance that they have been produced to comply with the requirements of that standard under a well-defined system of inspection, testing and quality control which is devised and supervised by BIS and operated by the producer. Standard marked products are also continuously checked by BIS for conformity to that standard as a further safeguard. Details of conditions under which a licence for the use of the Standard Mark may be granted to manufacturers or producers may be obtained from the Bureau of Indian Standards.

6. PACKING

6.1 Unless otherwise agreed upon by the buyer and the seller, the cloth shall preferably be packed in bales or cases in conformity with the procedure laid down in IS : 1347-1972† or IS : 293-1980‡.

7. SAMPLING

7.1 The scale of sampling and criteria for conformity as given in IS : 3919-1966§ shall be followed in respect of physical characteristics, namely, number of threads per decimetre, weight and dimension.

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*Glossary of terms pertaining to defects in fabrics.

†Specification for inland packaging of cotton cloth and yarn (*first revision*).

‡Code for seaworthy packaging of cotton yarn and cloth (*third revision*).

§Methods for sampling cotton fabrics for determination of physical characteristics.

7.2 The scale of sampling and criteria for conformity as given in IS : 5463-1969* shall be followed in respect of chemical characteristics of colour fastness, dimensional changes and scouring loss.

TABLE 1 CONSTRUCTIONAL PARTICULARS OF HANDLOOM COTTON CALICO CLOTH, BLEACHED OR DYED

(*Clause* 3.1)

SL No.	CHARACTERISTICS	REQUIREMENT	METHOD OF TEST
(1)	(2)	(3)	(4)
i)	Count of yarn (for guidance only) Tex (cotton count)		
	a) Warp	23 tex (or 26s)	
	b) Weft	23 tex (or 26s)	
ii)	Number of threads, per dm		IS : 1963-1981*
	a) Ends	270	
	Tolerance	±5 percent	
	b) Picks	220	
	Tolerance	±5 percent	
iii)	Weight of fabric. g/m2	120	IS : 1964-1970†
	Tolerance	±5 percent	
iv)	Dimension		IS : 1954-1969‡
	a) Length, m	As declared	
	Tolerance	(*see* NOTE)	
	b) Width, cm	90 or as declared	
	Tolerance	− 2 percent	
v)	Weave	Plain	Visual

NOTE — The length shall not be less than the declared length.

*Methods for determination of threads per unit length in woven fabrics (*second revision*).

†Methods for determination of weight per square metre and weight per linear metre of fabrics (*first revision*).

‡Methods for determination of length and width of fabrics (*first revision*).

|| Methods for sampling of cotton fabrics for chemical tests.

TABLE 2 REQUIREMENTS OF HANDLOOM COTTON CALICO CLOTH, BLEACHED OR DYED

(*Clause* 3.2)

Sl No.	Characteristics	Requirements	Method of Test
(1)	(2)	(3)	(4)
	i) Colour fastness rating to (for dyed cloth only)		
	a) Light	5 or better	IS : 686-1985* or IS : 2454-1985†
	b) Washing : Test 4		IS : 765-1979‡
	1) Change in colour	4 or better	
	2) Staining on cotton	4 or better	
	c) Bleaching		IS : 762-1956§
	1) Change in colour	4 or better	
	2) Staining on cotton	4 or better	
	d) Perspiration		IS : 971-1983 ‖
	1) Change in colour	4 or better	
	2) Staining on cotton	4 or better	
	ii) Dimensional change, percent, *Maximum*	4	IS : 2977-1964¶
	iii) Scouring loss, percent, *Maximum*	2·5	IS : 1383-1977** (mild method)

*Methods for determination of colour fastness of textile materials to daylight (*first revision*).

†Methods for determination of colour fastness of textile materials to artificial light (xenon lamp) (*first revision*).

‡Method for determination of colour fastness of textile materials to washing : Test 4 (*second revision*).

§Method for determination of colour fastness of textile materials to hypochlorite bleaching.

‖ Method for determination of colour fastness of textile materials to perspiration (*first revision*).

¶Method for determination of dimensional changes of woven fabrics (other than wool) on soaking in water.

**Methods for determination of scouring loss in grey and finished cotton textile materials (*first revision*).

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